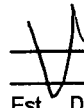
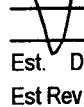


Date: Monday, 16/10/2006 9:24:29 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 28972		
Estimate Number	: 11704		
P.O. Number	: N/A	Part Number	: D2725
This Issue	: 16/10/2006 S.O. No. : N/A	Drawing Number	: D2725 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 28972	Material	: P/A
Written By	: 	Due Date	: 20/10/2006 Qty: 20 Um: Each
Checked & Approved By	: 		
Comment	: Est. D 99.02.11 Added 4 per Blank Est Rev:E Now on Waterjet 06-10-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
-----	--------------------	--------------------------



Comment: Qty.: 0.1815 f(s)/Unit Total : 3.6309 f(s)

~~6061 T6 Bar .178" x 4.0"~~

Material: 6061-T6 (QQ-A-250/11) 4" x 0.188" Thick

Note: 1 Blank makes 4

Batch: *119524* *MA 06/10/17*

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2725

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

SECOND CHECK

4.0

QC8



(20)

(20)

Comment: SECOND CHECK

06/10/23
06.10.15 *(20)*

3 *1903*

Date: Monday, 16/10/2006 9:24:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 28972

Part Number: D2725

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5756

16/10/23

(20)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

19 06/10/24

Job Completion



16 06.10.24

Date: Friday, 10/13/2006 9:30:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 28972	
Estimate Number : 11704	
P.O. Number :	Part Number : D2725
This Issue : 10/13/2006 S.O. No. :	Drawing Number : D2725 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run :	Material :
Written By : <u> </u>	Due Date : 10/20/2006 Qty: 20 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est. D 09.02.11 Added 4 per Blank	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
-----	--------------------	--------------------------



Comment: Qty.: 0.1815 f(s)/Unit Total : 3.6309 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 (QQ-A-250/11) 4" x 0.188" Thick
 Note: 1 Blank makes 4
 Batch: _____

W. J. Johnston

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 8.3" -0.000"/+0.030"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2725
 Tumble to remove rough edges
 Deburr any rough edges after tumbling

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:30:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 28972

Part Number: D2725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

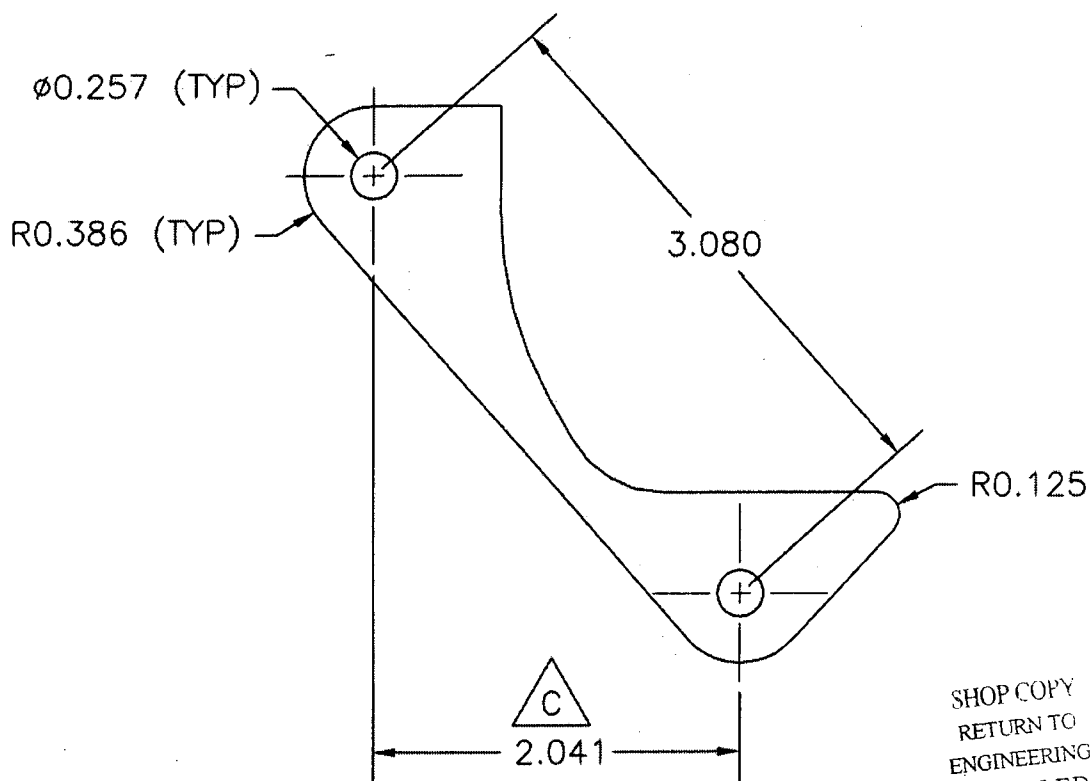
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>MA</i>	APPROVED <i>KS</i>	DRAWING NO. D2725	REV. C SHEET 1 OF 1
DATE 98.10.19		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	97.12.04	NEW ISSUE	
B	98.05.04	0.188 THICK WAS 0.125	
C	98.10.19	REVISED GEOMETRY FOR 5.5° STEP ANG.	

RELEASED
13.11.11 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28972

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED